

Date: Monday, 3/13/2006 10:01:19 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TOW RING
Job Number	: 26210		
Estimate Number	: 10396		
P.O. Number	: <u>N/A</u>	Part Number	: D2968041
This Issue	: 3/13/2006	S.O. No.	: <u>N/A</u>
Prsht Rev.	: NC	Drawing Number	: D2968- UNDER REVIEW
First Issue	: 3/13/2006	Project Number	: N/A
Previous Run	: 24537	Drawing Revision	: B1
		Material	: <u>N/A</u>
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 4/10/2006
Checked & Approved By	: <u>SEE ABOVE DATE & USER</u>	Qty:	40 Um: Each
Comment	: Est:C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	26210A	STEM
	Comment: Sub-Component STEM	
2.0	26210B	RING
	Comment: Sub-Component RING	
3.0	D29681	Stem
	Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)	
	Stem	
	Pick:	
	Qty Part Number Description	Batch
	1 D2968-1 Stem	<u>B26210A</u>
		<u>CPL 06.04.19</u>
4.0	D29685	Ring
	Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)	
	Ring	
	Pick:	
	Qty Part Number Description	Batch
	1 D2968-5 Ring	<u>B24537 B26210B</u>
		<u>CPL 06.04.19</u>
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1	
	Weld D2968-1 & D2968-5 as per Dwg D2968 & QSI 004 using 4130 welding rod Identify as D2968-041	
	Batch: <u>M15684</u>	
		<u>CPL 06.04.19</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 10:01:19 AM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

1206/04/19

7.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 1044

Description: D2968-041 to heat treat to ultimate tensile strength

125ksi as per Dwg D2968

Conformity sheet required

42mlc
6/4/19

Issue P/O: 1049

Cad Plate per QQ-P-416F Class I Type II

Conformity sheet required

C206104/20 (42)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

6/31/31 (42)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CAD PLATE

Jan 31 (42)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DO NOT POWDER COAT THREADS

a-m 06-06-07 (42)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

6/6/08 42

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 113

6/6/08 (42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 05/06/08

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2968041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

DD 06/06/08 (42)

Job Completion



u 06-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

MANCO DOMPLEX

8885 Crescent 3
Anjou (Québec) H1J 1B5
Tél.: 514-355-7867
Fax: 514-355-8750

ATTN: LINDA

613 632-4443

CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE

1611

Dart Aerospace Ltd
Client / Customer

00918-041
de la pièce / part

202049
Votre # de commande / Your purchase order #

098562
Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector <u>Volante</u>	Date, équipe / Date, shift <u>May 19, 2006</u>
Placage / Plating <u>002 H145 Class 1 Type II 14100 cadmium</u>	
Quantité totale / Total quantity <u>42</u>	Quantité inspectée / Inspected quantity <u>42</u>
Adhésion / Adhesion <u>Good</u>	
Épaisseur / Thickness L.C.D.	H.C.D. Moy. / aver. <u>0.0005 06-05-31</u>
Coussures, taches / Leach, spots <u>NO</u>	Rugosité / Roughness <u>NO</u>
Quantité approuvée / Approved quantity <u>42</u>	Quantité rejetée / Rejected quantity <u>—</u>

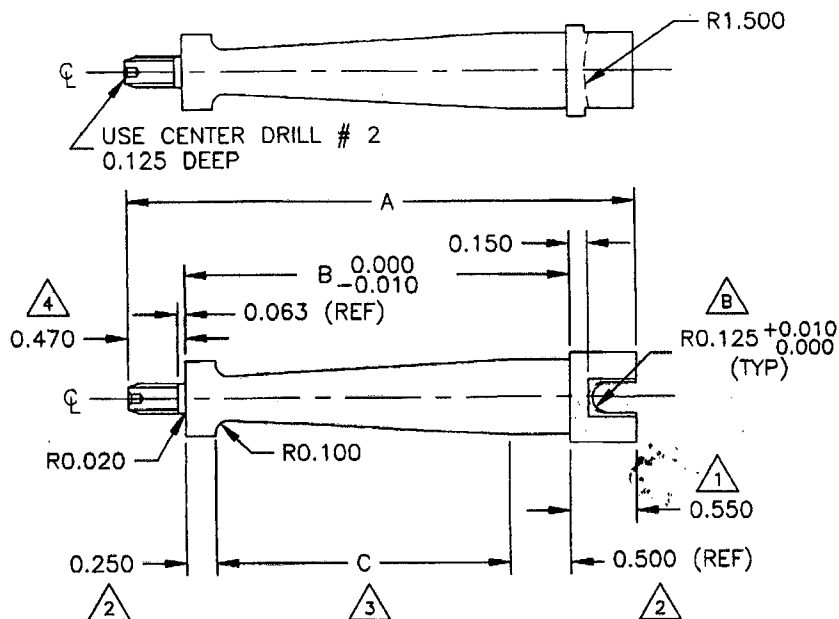
Commentaires / Comments

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of

**MANCO
DOMPLEX**



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

△ Ø0.750 O.D.

△ Ø0.625 O.D.

△ MACHINE UNIFORM TAPER FROM Ø0.363 O.D. TO Ø0.625 O.D.

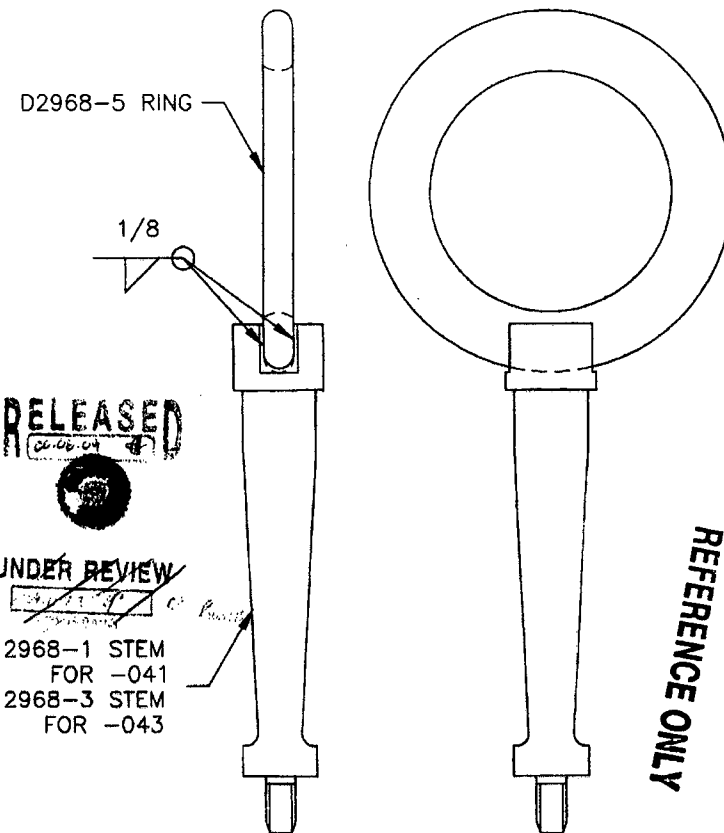
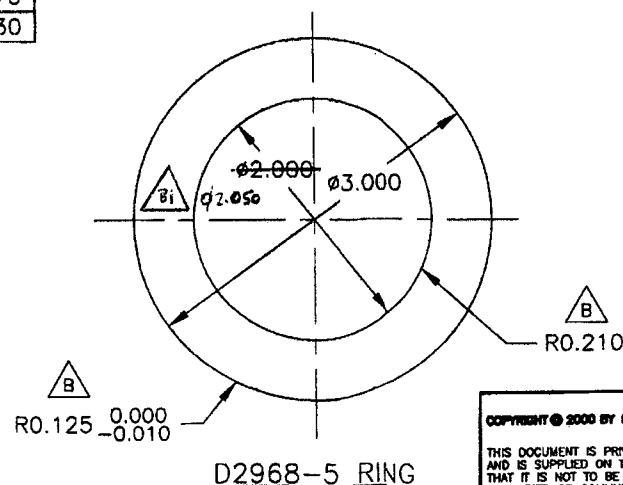
△ 1/4-28 UNF THREAD WITH 0.063 GRIP
MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2968-5 RING:

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED

UNDER REVIEW

USE 2968-1 STEM
FOR -041
USE 2968-3 STEM
FOR -043

REFERENCE ONLY

D2968-041 AND D2968-043 TOW RING:

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
FINISH: CAD PLATE ENTIRE ASSEMBLY PER

QQ-P-416F CLASS I TYPE II

POWDER COAT WHITE (REF 4.3.5.2) PER DART

QSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	RF	DART DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO. D2968
DATE	00.05.31	TITLE TOW RING

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DART AEROSPACE LTD.

2002 SWI 0501 2004-01-18

REV. B
SHEET 1 OF 1
SCALE
1:1